



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4463-041
Job Sheet 176062



Part No: D4463-041

Job Qty: 2 ea

Part Name: Tank Top Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 4/27/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D SHEETS 1,2 IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B 12.04.25 AS PER
DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		4/26/18	0.00	0.00	Start Up Waterjet		SC 18/04/15
100	Waterjet	2 pcs		4/26/18	0.01	0.79	Waterjet1		SC 18/04/15
110	QC	2 pcs		4/26/18	0.00	0.00	QC2 Waterjet-3		SC 18/04/15
120	QC	2 pcs		4/26/18	0.00	0.00	QC8-4		38
130	Small Fab	2 pcs		4/26/18	0.00	0.75	Small Fab-6		9-88
140	QC	2 pcs		4/26/18	0.00	0.00	QC5		9-88
150	HandFinish	2 pcs		4/26/18	0.00	0.32	HandFinish1		SA 18-04-30
160	QC	2 pcs		4/26/18	0.00	0.00	QC7-3		9-88
170	Small Fab	2 pcs		4/27/18	0.00	0.75	Small Fab-6		9-88
180	QC	2 pcs		4/27/18	0.00	0.00	QC5		APR 30 2018
190	Packaging	2 pcs		4/27/18	0.00	0.00	Packaging3-2		DC 0018-05-01
200	QC21-SA	2 Ea		4/27/18	0.00	0.00	QC21	DAS 21 9-88	MAY 01 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	7.7280 sf (3.864 ea)	90-Start up Operation	
MS20426AD3-4	Rivet	96 Ea (48 ea)	170-Small Fab	F/M1364/4-2
NAS1473R3	Anchor Nut	48 Ea (24 ea)	170-Small Fab	5058179 44X F/M1377/4-40 44X

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	8	262	0
170-Small Fab	MS20426AD3-4	96	3,688	0
	NAS1473R3	48	84	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube ☐ TL ☐		Engineering ☐ Quality ☐ Other ☐ (QSI042) Approval _____ Completed By _____ / Supervisor Verification _____ Coordinator _____ val _____					
Date : _____		Step #: _____		Container No: S061430 Part: D4463 - 041 Job No: 176062 Serial No/Batch: S061430 Date: 04/16/18 DART AEROSPACE 1270 Aberdeen Street Markham, ON L3R 9K7 CANADA TEL.: 1 913 692-8200 Email: sales@dartaero.com www.dartaerospace.com							
Description Work Order Deviation											
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concer ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> BUM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concer ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BUM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:50%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____											

(76067)

DART AEROSPACE LTD		Work Order:	17194
Description: Tank Top		Part Number:	D4463-1
Inspection Dwg: D4463	Rev: D	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0.098	1		VSC-01	
Ø0.206	+0.005/-0.001	Ø0.206	1			
Ø1.00	+0.012/-0.001	Ø1.00	1			
1.15	+/-0.030	1.154	1			
1.85	+/-0.030	1.853	1			
2.20	+/-0.030	2.208	1			
2.30	+/-0.030	2.307	1			
5.29	+/-0.030	5.30	1			
8.30	+/-0.030	8.30	1			
8.93	+/-0.030	8.95	1			
8.98	+/-0.030	8.988	1			
9.31	+/-0.030	9.316	1			
10.42	+/-0.030	10.43	1			
11.26	+/-0.030	11.27	1			
1.61	+/-0.030	1.616	1			
1.68	+/-0.030	1.688	1			
1.82	+/-0.030	1.826	1			
3.41	+/-0.030	3.417	1			
3.79	+/-0.030	3.80	1			
6.43	+/-0.030	6.44	1			
7.36	+/-0.030	7.366	1			
7.80	+/-0.030	7.80	1			
10.75	+/-0.030	10.75	1			
11.38	+/-0.030	11.39	1			
11.80	+/-0.030	11.80	1			
13.27	+/-0.030	13.277	1			
1.15	+/-0.030	1.155	1			
3.00	+/-0.030	3.00	1			
3.26	+/-0.030	3.26	1			
7.00	+/-0.030	7.00	1			
10.74	+/-0.030	10.744	1			
11.00	+/-0.030	11.00	1			
11.63	+/-0.030	11.63	1			
15.29	+/-0.030	15.296	1			
15.48	+/-0.030	15.488	1			
19.48	+/-0.030	19.48	1			
23.48	+/-0.030	23.48	1			
23.67	+/-0.030	23.68	1			
24.11	+/-0.030	24.12	1			
27.46	+/-0.030	27.47	1			

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DAS

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18/04/15